

Work Order ID 151458

Tuesday, September 27, 2016 11:53:55 AM

646.3910

B 1 5 1 4 5 8

151458

Page 1

Item ID: 646.3910

P E V . N / C 1 Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 9/6/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/27/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

DAS**21**Date: **SEP 28 2016**

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

646.3900

nc1

110

0.01

110

Waterjet

Memo

0.10

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: NC1Prog Rev: NC1

2-Deburr if necessary

(20)DC 16/10/08

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.03

Quality Control

(20)DC 16/10/08

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Fast Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

151458

Tuesday, September 27, 2016 11:53:55 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/6/2016 **Start Qty:** 20.00 ***20***

Cust Item ID:

Required Date: 9/27/2016 **Req'd Qty:** 20.00 ***20***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

130

0.07

QC

Memo

Quality Control

DAS
38
9-89
OCT 11 2016

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

140

Outsource3

Memo

799.97

Outsource process - Cad plate

Issue P/O: 33948
Cad Platting

NOV 15 2016

DAS
26
9-85

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.07

Packaging

NOV 18 2013

DAS
13
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER : ☐									

151458

Tuesday, September 27, 2016 11:53:55 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/6/2016 **Start Qty:** 20.00 ***20***

Cust Item ID:

Required Date: 9/27/2016 **Req'd Qty:** 20.00 ***20***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							38 9-89
160						20			
QC	Memo	0.07							
Quality Control									16-11-18
170	Identify as per dwg & Stock Location <u>CCK/D8A</u>	0.00							
170						20	DAS 6 9-89		NOV 18 2016
Packaging	Memo	0.03							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
180	QC21- Final Inspection - Work Order Release	0.00							NOV 18 2016
180						DAS 21 9-89			NOV 18 2016
QC	Memo	0.33							
Quality Control									
							DAS 21 9-89		NOV 18 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

Picklist Print

Tuesday, September 27, 2016 11:53:55 AM

Page 1

Work Order ID: 151458

151458

Parent Item: 646.3910

646.3910

Parent Item Name: Shim

Start Date: 9/6/2016

Required Date: 9/27/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020		Purchased	No			110	sf	13.7000	0.03	0.631578			

MC1095S 020

C1095 Blue Tempered Spring Steel Sheet .020 mcmaster p/n: 9036K499

02/16/10/08

Location

Loc Qty

Loc Code

MAT019

13.7

M130477

1.7

M135525

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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		OTHER : ☐							



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05243

SHEET 1 OF 1

DWG NO. 646.3900

REV: N/C

PREPARED BY J. BECKER

DATE: 11/13/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: SHIM

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: REVISED VIEWS. UPDATED TEMPLATE AND TITLE BLOCK.

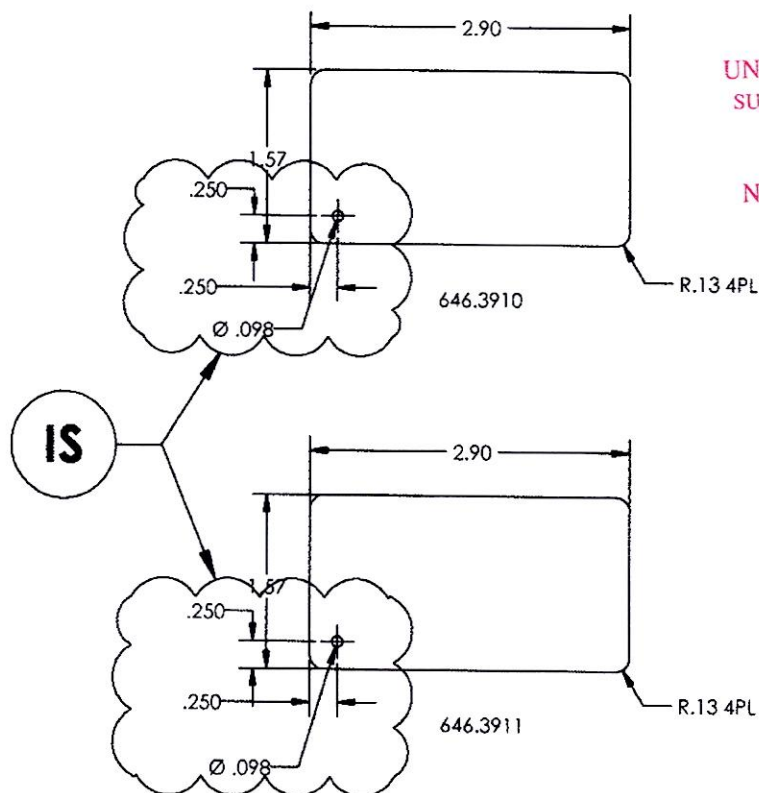
ECR:

15-275

ACTION ITEM:

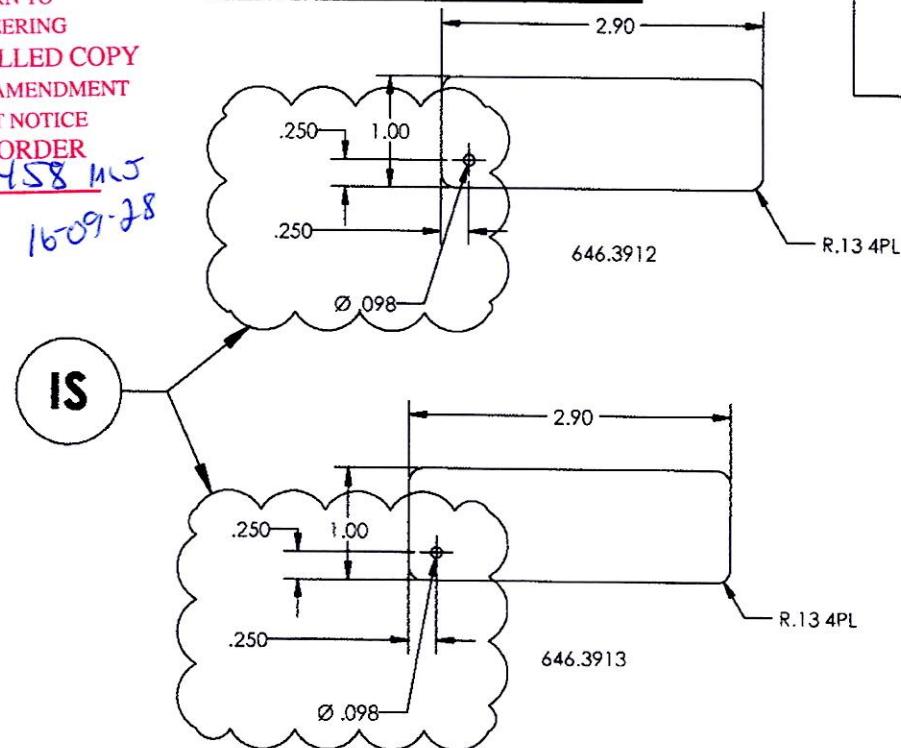
1. N/A.

SHEET 1, ZONE B2 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151458 MJS
16-09-28

SHEET 1, ZONE B5 IS:



SHEET 1, ZONE C2 IS:

SHEET 1, ZONE C5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

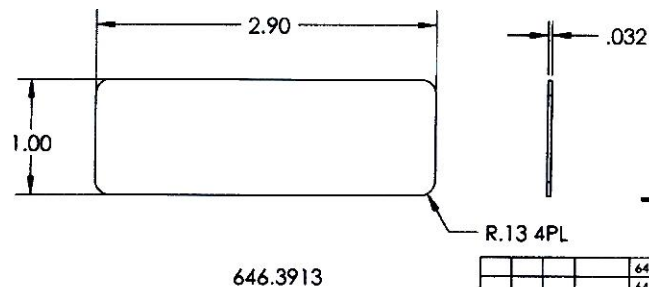
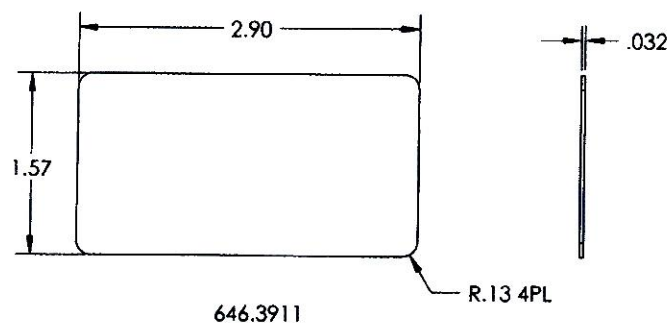
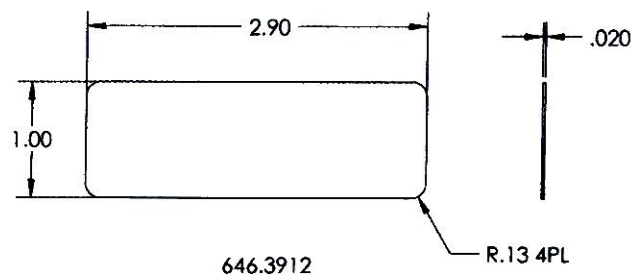
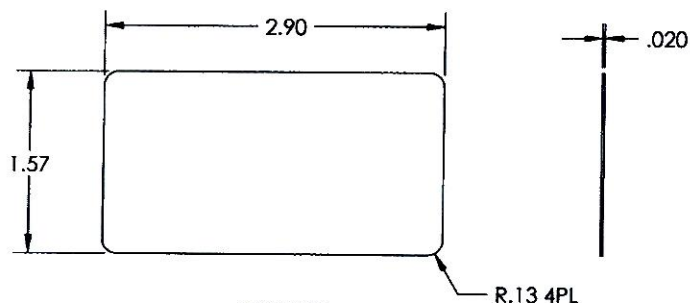
☐ YES ☒ NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

NOTES:

- 1 MATERIAL: SHIM STOCK, C1095 BLUE-TEMPERED SPRING STEEL
- 2 FINISH: CAD PLATE PER QQ-P-416 TYP II CL2
- 3 IDENTIFY IAW MPP-120



UNINCORPORATED ECN(s)

05243

			646.3913	SHIM	△	△
			646.3912	SHIM	△	△
			646.3911	SHIM	△	△
			646.3910	SHIM	△	△
QTY		FIND #	PART #	DESCRIPTION	MATL	SPEC.
NEXT ASSY (S)				PARTS LIST		
646.4000				APICAL INDUSTRIES		
				2608 TEMPLE HEIGHTS DR.		
				OCEANSIDE, CA. 92056-3512 (760)724-5300		
				SHIM		
ORIGINAL DATE (SHEET 1 OF 1) 1 HURF P. BRAVO APPROVAL 646.4000 06/05/08 (CONTACT 16)				REV 07/06/08 DATE: 06/05/08 SCALE: NONE SHEET 1 OF 1		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1/16" DECIMALS ±.01 3/16" DECIMALS ±.005 ANGLES ±.5°				REV 07/06/08 DATE: 06/05/08 SCALE: NONE SHEET 1 OF 1		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33948**

Purchase Order Date 10/14/2016

PO Print Date 10/14/2016

Page Number 1 of 2

Order From : VC-ALT01
GROUP ALTECH
2455 HALPERN
ST LAURENT, MONTREAL H4S 1N9

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

OCT 17 2016

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514-335-3666	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:	FedEx Overnight collect	FOB	FOB Origin
Ship Acct:			

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	151458	646.3910 SHIM	10/26/2016 Yes 10/26/2016		20.00	\$6.15	\$122.92
	CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2						
						Line Total:	\$122.92
2	151683	646.3912 SHIM	10/26/2016 Yes 10/26/2016		20.00	\$6.15	\$122.92
	CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2						
						Line Total:	\$122.92
3	151450	647.7703 STRUT	10/26/2016 Yes 10/26/2016		4.00	\$6.15	\$24.58
	CAD PLATE PER QQ-P-416F, TYPE II, CLASS I						

Note:

10/14/2016



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.:(514)335-3666 Fax.:(514)335-3868
Internet : www.groupaltech.com

**Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance**

Bon-Livraison / Pk.Slip # : 122284-1 11/11/2016
Bon-Commande. / W.Order # : 122284
Client P.O. # : 33948
Transport :

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	<u>No. Job</u> <u>No. Réf</u>	<u>NoSerie / Part Number</u> <u>Nom-Produit / Product</u>	<u>Traitement</u> <u>Process</u>	<u>Poids</u> <u>Weight</u>	<u>Qté</u> <u>Qty</u>	<u>Envoyé</u> <u>Sent</u>	<u>A venir</u> <u>BO</u>
1	UNIT	646.3910 Rev.	CADMIUM QQ-P-416F TY:2 CL:2 + HYDRO ENBRITAL RELIEF	0.00	20	20	0
2	UNIT	646.3912 Rev.	CADMIUM QQ-P-416F TY:2 CL:2 + HYDRO ENBRITAL RELIEF	0.00	20	20	0
3	UNIT	647.7703 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITALMENT RELIEF (BAKE)	0.00	4	4	0
4	UNIT	647.7703 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1 + HYDROGEN ENBRITALMENT RELIEF (BAKE)	0.00	4	4	0

DAS
26
9-89

NOV 15 2016

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

AK

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.